

Wednesday, 28/05/2008 1:45:49 PM

Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	205 BEARPAW INSTALLATION KIT (48")
Job Number :	38806		
Estimate Number :	12283		
P.O. Number :		Part Number :	D205564011
This Issue :	28/05/2008	Drawing Number :	D2521
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	28/04/2008	Drawing Revision :	J
Previous Run :	37726	Material :	
Written By :		Due Date :	15/05/2008
Checked & Approved By :	JLD 08.5.28	Qty:	12 14 Um: Each
Comment :	Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

08/06/04 20 JLD
08.5.28

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: MFG ENGINEERING

Program Batch Number

3.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 13.6500 sf(s)/Unit Total: 191.4000 sf(s)

blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6

Material: Black UHMW 1"

(MUHMWB10)

Batch: M108013 (x9) M106161 (x15)

batch # not in computer
M.A 08/06/04

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

08/06/02 J.L/M.A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Wednesday, 28/05/2008 1:45:49 PM
User: Julie Lecoq

Process Sheet

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Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/06/12 J.L / M.A

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/06/18 (X12)

7.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total: ~~51.8000~~ f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

B35769

AS 08/06/20 (X12)

8.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total: ~~280.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block

B38173

AS 08/06/20 (X12)

9.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: ~~280.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer

B37210 x 22

B38188 x 218

AS 08/06/20 (X12)

10.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total: ~~112.0000~~ Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

B338618

B32859 x 88

* This Batch was there... then it went to La-La land. TAKE Bath out

AS 08/06/20 (X12)

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Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 38806

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3544041

Clamp



48



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~50.0000~~ Each(s)

CLAMP

Batch:

B30396 x4 B36760 x44

JS 08/06/20 (x12)

12.0

AN413A

Bolt



96



Comment: Qty.: 8.0000 Each(s)/Unit Total : ~~112.0000~~ Each(s)

Bolt

Batch:

M107534

JS 08/06/20 (x12)

13.0

AN415A

Bolt



240



Comment: Qty.: 20.0000 Each(s)/Unit Total : ~~200.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN4-15A

Bolt

M107321 x4

M107737 x137236

* This Batch not in comp. 4 from an old kit.

JS 08/06/20 (x12)

14.0

AN960JD416

Washer



240



Comment: Qty.: 20.0000 Each(s)/Unit Total : ~~200.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M107939

JS 08/06/20 (x12)

15.0

MS21042L4

Nut



240



Comment: Qty.: 20.0000 Each(s)/Unit Total : ~~200.0000~~ Each(s)

Nut

Batch:

M107478

JS 08/06/20 (x12)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS



JS 08/06/20 (x12)

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Job Number: 38806

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rev C

JS 08/06/20 (X12)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/20 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-20

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓			
B	0.90	0.96	.930	✓			
C	0.27	0.330	.310	✓			
D	0.470	0.530	.505	✓			
E	21.740	21.760	21.750	✓		tape	
F	0.72	0.780	.760	✓			
G	0.35	0.410	.381	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.430	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.50	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.935	✓			
N	44.47	44.530	44.500	✓		tape	
O	6.590	6.650	6.623	✓			
P	0.940	0.980	.945	✓			
Q	18.97	19.03	19.00	✓		tape	
R	0.350	0.410	.380	✓			
S	0.740	0.780	.743	✓			
T	0.240	0.280	.244	✓			
U	0.370	0.410	.372	✓			
V	0.740	0.780	.743	✓			
W	0.740	0.780	.745	✓			

Measured by: J.L.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/06/11	Date: 08/06/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	[Signature]

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NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 38806

RELEASED

06 08-23

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

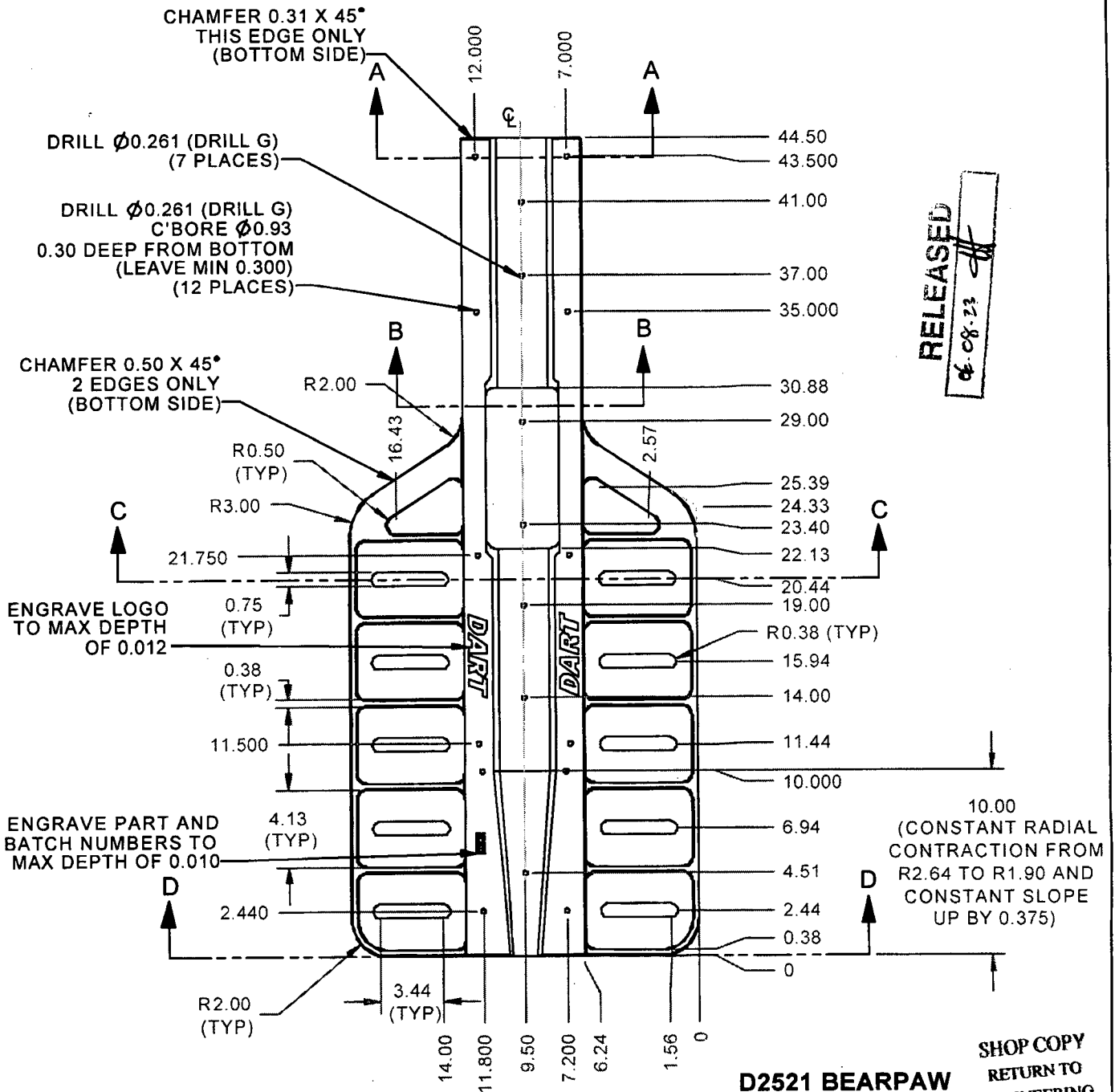
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DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 2 OF 3
DATE 06.07.28	TITLE 205 BEARPAW	SCALE 1:8	

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.005)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
 - 6) PART IS SYMMETRIC ABOUT C
- SHOP COPY
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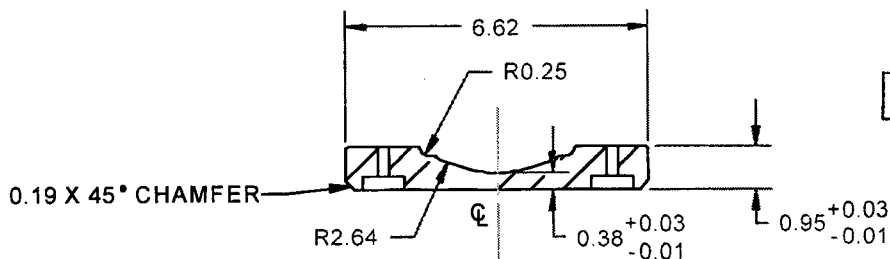
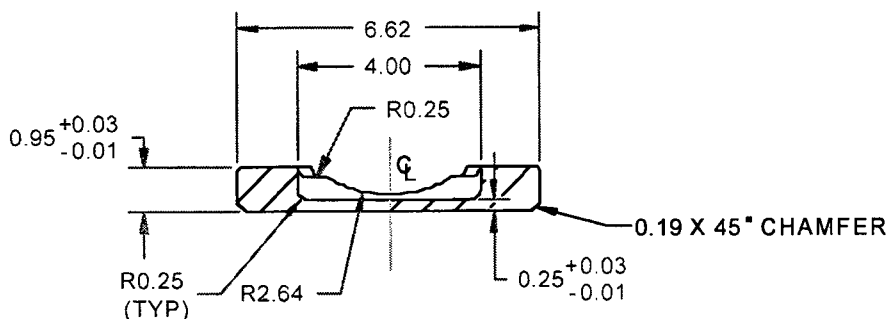
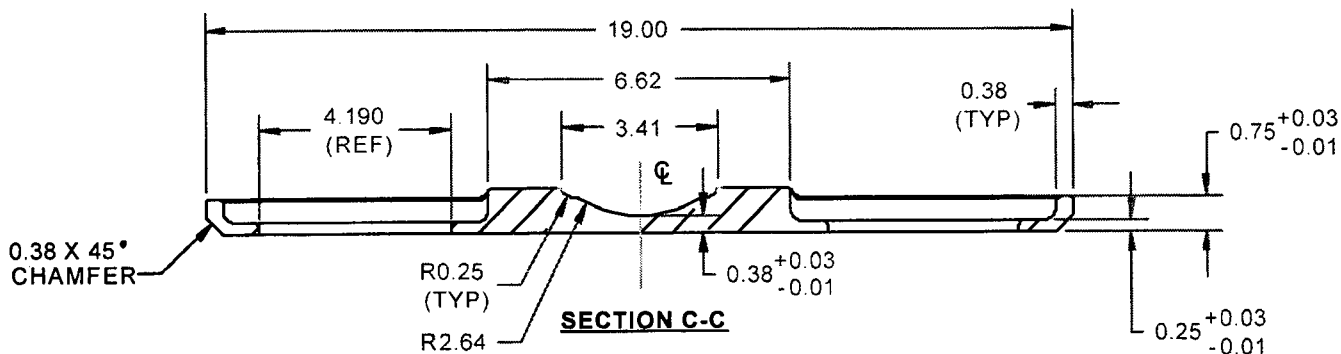
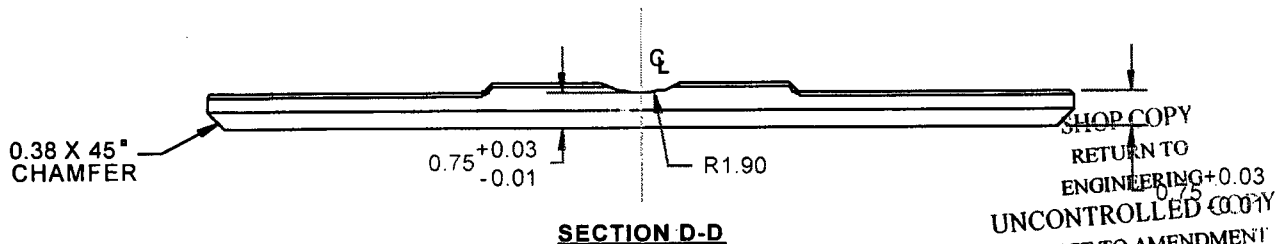
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CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE 1:4

**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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